

Date: Monday, 27/04/2009 11:08:43 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE POSITIONER
Job Number : 47541	
Estimate Number : 13530	
P.O. Number :	Part Number : PB674300127
This Issue : 27/04/2009 S.O. No. :	Drawing Number : B6743001 P.4
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 45653	Material :
Written By :	Due Date : 04/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>MF 09-04-27</u>	
Comment : Est Rev:A 08-07-29 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300135	PB67-43001-35 Lower Pad Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-35 Lower Pad Assembly batch: <u>45030</u> <u>MF 09-04-27</u>		
2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-31 Upper Restraint Weldment batch: <u>45031</u> <u>MF 09-04-27</u>		
3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-29 Blade Positioner Weldment batch: <u>47056</u> <u>MF 09-04-27</u>		
4.0	PB6743001285	PB67-43001-285 Upper Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-285 Upper Tube batch: <u>B44974</u> <u>MF 09-04-27</u>		
5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-19 Inner Tube and Retainer Bu batch: <u>B45039</u> <u>E-B09/05/06</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Extension Tube Adjustmnt

batch: 347365

29.09/05/06

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Adjustmnt Fitting

batch: 46246

mf 09-04-27

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp Bushing

44972

mf 09-04-27

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

batch: m ~~110155~~ 110155

mf 09-04-27

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch: m110985

mf 09-04-27

11.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m18057

mf 09-04-27

12.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m108987

mf 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: m110002

MF 09-04-27

14.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch: m107378

MF 09-04-27

15.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WASHER

batch: m111117

MF 09-04-27

16.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Inventory

batch: m18431

MF 09-04-27

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube

2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg

3- assemble all parts as per dwg PB67-43001

2/09/05/07 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/09/05/07 ②

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 47586

2/09/05/07 ③

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

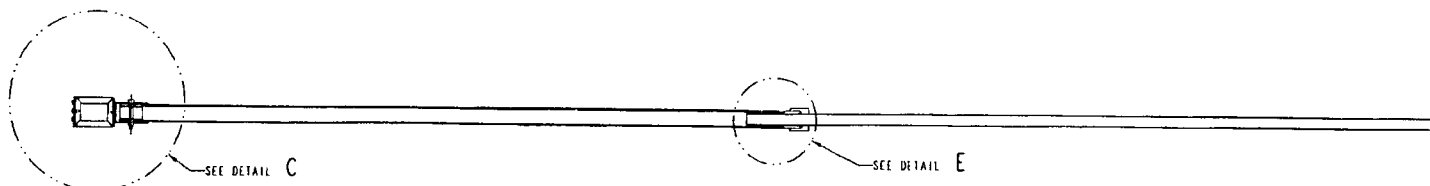
Job Completion



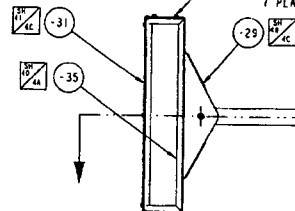
MF 09-05-07

RELEASED
44 Oct 21 2

8 7 6 5 4 3 2 1



MS27039-1-09 SCREW
NAS1149T0316P WASHER
Ø .193 THRU
MATCH DRILL -29 WITH NUT PLATE
LOC'S OF -35
7 PLACES

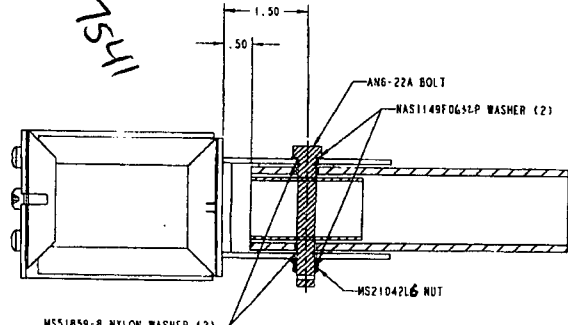
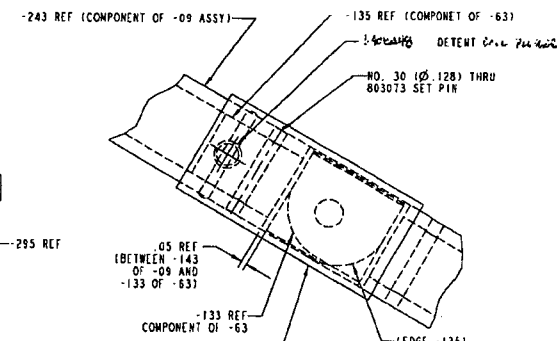
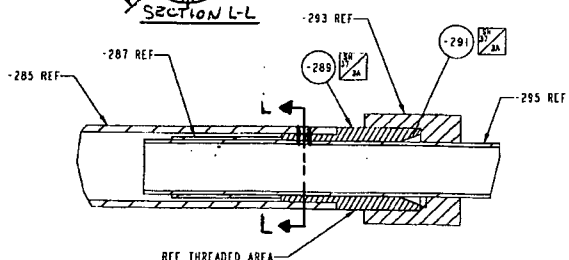
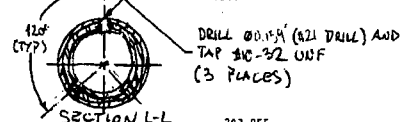


-285
-283
-19

#47541

① -27 BLADE POSITIONER

FULLY EXTENDED THIS VIEW
SCALE 0.200



DETAIL C
SCALE 1.000
(-27 ASSY)

DETAIL E
SCALE 1.000
(-27 ASSY)

DETAIL B
SCALE 2.000
(-03 ASSY)

PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75052

DATE	REV	BY	CHK
10/21/84	1	OSUV8	BT

867-43001

4 of 45

ORIGINAL

8 7 6 5 4 3 2 1